



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DAS
13
9-89

MAR 27 2018

D2855-3

Job Sheet 174938



Part No: D2855-3

Job Qty: 10 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 4/26/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs	4/25/18	4/25/18	0.00	0.00	Purchasing		AT 18-04-27
110	Packaging	10 pcs	4/25/18	4/25/18	0.00	0.00	Packaging2		AT 18-04-27
120	QC	10 pcs	4/25/18	4/25/18	0.00	0.00	QC6		38
130	Small Fab	10 pcs	4/25/18	4/25/18	0.00	0.71	Small Fab-2		18/05/29
142	Mill Conv	10 pcs	4/25/18	4/25/18	0.00	0.83	Mill Conv 1		18/05/29
143	QC	10 pcs	4/25/18	4/25/18	0.00	0.00	QC5		38
150	Powdercoat	10 pcs	4/25/18	4/25/18	0.00	0.11	Powdercoat1		BER 18-06-04
160	QC	10 pcs	4/25/18	4/25/18	0.00	0.00	QC3		18-4-06
170	Small Fab	10 pcs	4/26/18	4/26/18	0.00	0.36	Small Fab-2		BER 18-06-04
180	QC	10 pcs	4/26/18	4/26/18	0.00	0.00	QC5		18-4-06
190	Packaging	10 pcs	4/26/18	4/26/18	0.00	0.00	Packaging3-1	FP001	BER 18-06-04
200	QC21-SA	10 Ea	4/26/18	4/26/18	0.00	0.00	QC21		JUN 04 2018

Part Op 100 - Issue P/O: 39047

Descriptions: 110 - Ensure Material Release Note is attached

130 - 1- Drill as per Dwg D2855 using DT8235

142 - 1- MILL to length as per dwg use DT10248 JAWS 2- Deburr

150 - START TIME: 9:30 FINISH TIME: 10:00

170 - Install Inserts as per Dwg D2855

190 - LOCATION : FP001

DAS
13
9-89

MAR 27 2018

X20

320°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2855P	Cap	10 pcs (1 ea)	100-Purchasing	5065861
ALS7-1032-225	Insert	20 Ea (2 ea)	170-Small Fab	5058138

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2855P	10	0	0
170-Small Fab	ALS7-1032-225	20	1,068	0



Container No: **S066002**



Cap

PART NO: **D2855-3**
Serial No/Batch: **S066002**
Revision:
Operation:
Change No:

Packaging

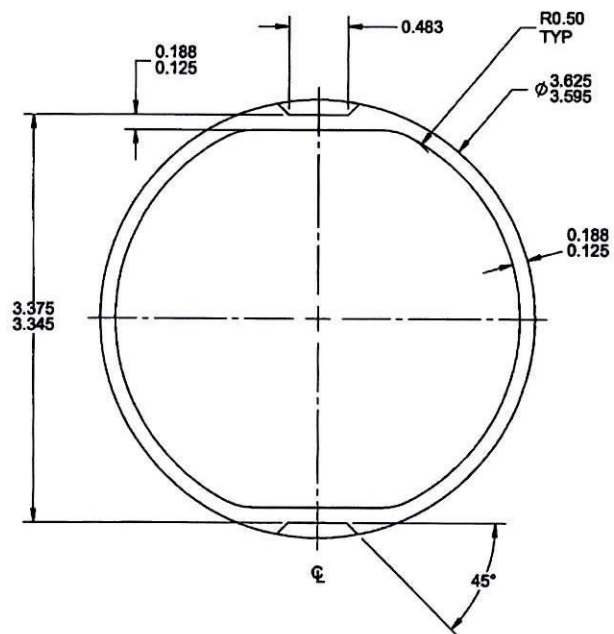
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 04/27/18
Job No: 174938

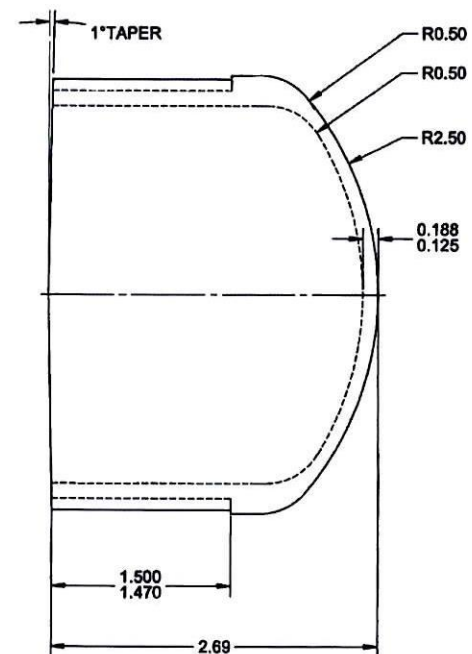
Part Specifications

Specifications could not be found.

Plex 3/23/18 10:13 AM Dart.Gagnon.Michelle



D2855C CASTING DETAIL CAP

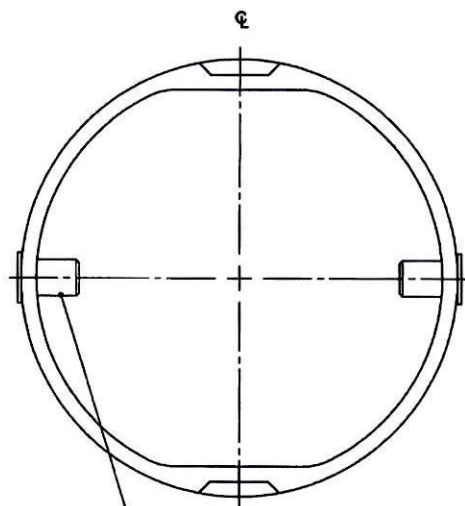


- NOTES:
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

RELEASED
2017-05-08
EN 17-519

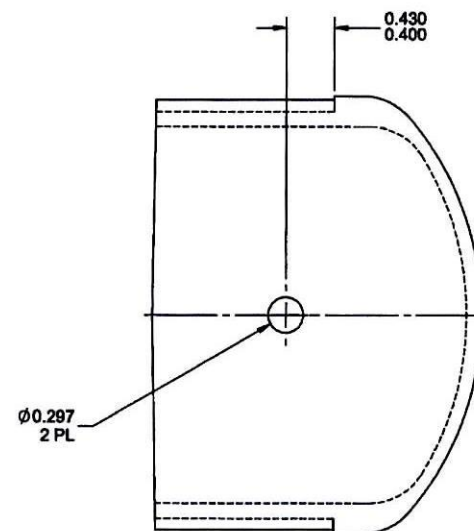
C	ADDED D2855-5 (ZN C8-4)	WK	17.03.01
B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN B8-1, A8-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	06.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)



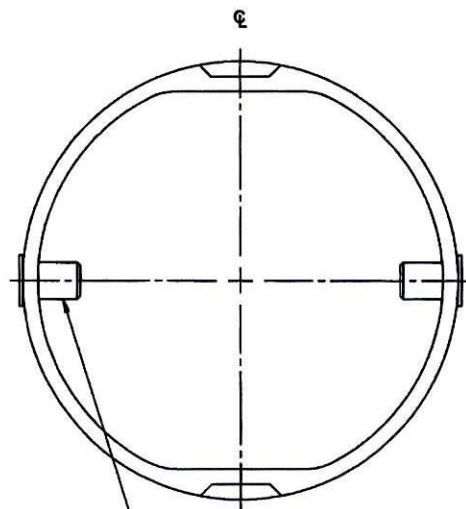
NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2017-05-08

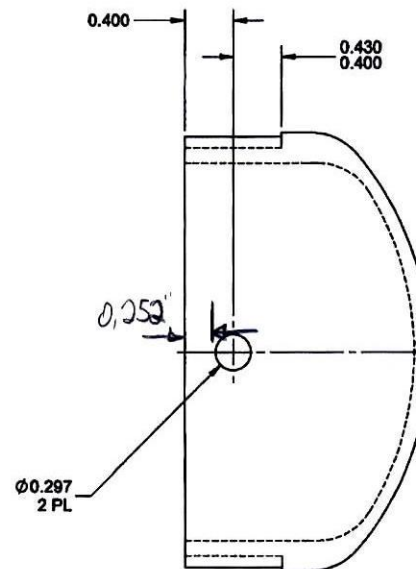
APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)



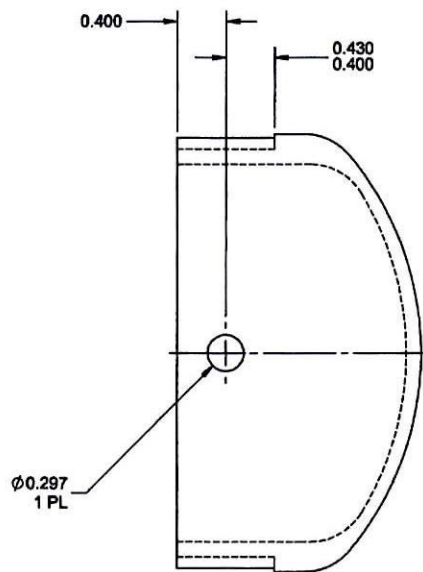
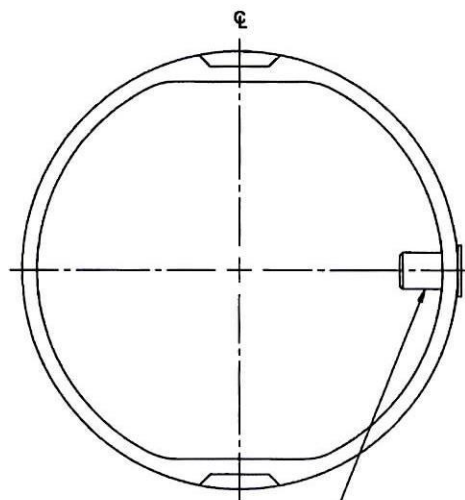
NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
1 PL

D2855-5 CAP
(MAKE FROM D2855C CASTING) $\triangle C$

- NOTES:
- 1) MATERIAL: MAKE FROM D2855C
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

APPROVED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039047**

Supplier: MES001-VC
Metallurgie SYCA
500 Principale, 0
St.Dominique
QC
JOH 1LO Canada
Phone: 450-261-0853
Fax: 450-261-0894

PO No: PO039047
PO Date: 2/15/18
Due Date: 4/9/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: net 30
Freight Terms:
Special Comments: ADMIN FEE INCLUDED IN PRICING OF PARTS.

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2855P		Cap As per Dwg D2855 Rev. C	Firmed	4/9/18	80 pcs	0 pcs	80 pcs	\$16.00/pcs	\$1,280.00
Line Item Note job# 172212										
2	D2855P		Cap As per Dwg D2855 Rev. C	Firmed	4/9/18	20 pcs	0 pcs	20 pcs	\$16.00/pcs	\$320.00
Line Item Note JOB NO. 174938										
									Grand Total:	\$1,600.00

Order Notes

rec'd At 1864/26

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

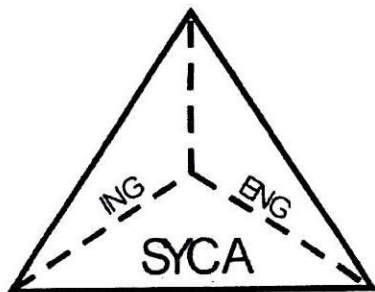
Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

CL

Plex 3/27/18 9:13 AM dart.lavoie.chantal



MÉTALLURGIE SYCA Inc.

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

WWW.SYCA-INC.COM

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2018-03-30TH

SHIPPING MEMO: 371882

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	107	D-2855	39047

DAS
38
9-88

All items specified in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ22022018

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

RESPONSIBLE: CARL JOBIN ING.

SA-101

ROUVILLE STATION INC.
1032, BOUL. RICHELIEU
RICHELIEU (QUÉBEC)
J3L-0L7

TEL : (450) 658-2183
TEL : (450) 658-2808
FAX : (450) 658-1461

356SR

Coulée # 118

ELEMENT:	SI	FE	CU	MG	MN	NI	TI	ZN	CR	SR
ALLIAGE	6.5 - 7.5	.50	.10	.30 - .45	.05	.	.20	.05	.	.
(356.1)		.20	.20	.25 - .45	.10		.20	.10		.007
A356.0										
ANALYSE MOYENNE:	6.948	.19	.048	.42	.02	.01	.10	.043	.006	.002

CHIEF DE LABORATOIRE:

Date : 2018-01-22

et accepté